

42

Date: Friday, 9/21/2007 12:58:10 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	206L BASKET BASE		
Job Number	34770A			Part Number	D2252041		
Estimate Number	11273			Drawing Number	D2252 REV E		
P.O. Number				Project Number	N/A		
This Issue	9/21/2007	S.O. No.		Drawing Revision	E		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	LARGE FAB ASSY	Due Date	10/20/2007	Qty:	1 Um: Each
Previous Run	34479A						
Written By							
Checked & Approved By	<i>HA 07.09.24</i>						
Comment	Est Rev I Revised as per Rev E 05-12-06 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:			Description :						
1.0	D31661			Basket Hoop						
	Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)									
	Pick:									
	Qty	Part#	Description	Batch	<i>B34423</i>					
5	D3166-1	Hoop			<i>PD 07-10-16</i>					
2.0	M304TS0750W065			304 SQ Tube .75x.75x.065W						
	Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)									
	3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: <i>M105604</i>				<i>PD 07-10-16</i>					
3.0	LARGE FAB 1			LARGE FABRICATION RESOURCE 1						
	Comment: LARGE FABRICATION RESOURCE 1									
	1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.									
	Cut 5 D2235-1 From D3166-1									
	2- Cut Ribs as per Dwg D2252									
	3-Drill hole in D2252-1as per Dwg D2252									
	4-Deburr & Remove all Markings from Material				<i>PD 07-10-16</i>					
4.0	D22531			Lug						
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)									
	Pick:									
	Qty	Part Number	Description	Batch						
2	D2253	Gusset		<i>B27553</i>	<i>PD 07-10-16</i>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D2252041

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Seq. #: Machine Or Operation:

Description :

5.0 D23273 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2327-3	Bushing	<u>B33D46</u>

PD 07-10-16

6.0 D2581 Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2581	Mounting Chanel	<u>54445</u>

PD 07-10-16

7.0 D2254 Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2254	Lug	<u>23121</u>

PD 07-10-16

8.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	HINGE	<u>33290</u>

PD 07-10-16

9.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty	Part Number	Description	Batch
32 sf	M304EX0.75-16F	Expanded Metal	<u>BM105913</u>

PD 07-10-16

10.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURC E 1

1-Weld as per Dwg D2252using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: H105521

PD 07-10-22 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 34770A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/07/10/25

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/10/25

13.0 POWDER COATING

POWDER COATING



M10 5068

(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-f 07/10/26

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-f 07/10/29

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m-f 07/10/29

16.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



U.S.A. 07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



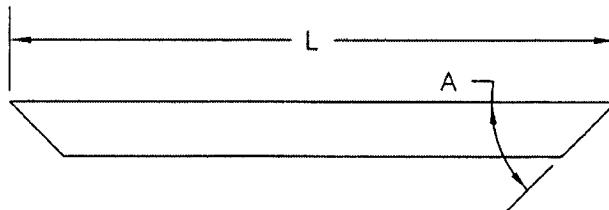
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

RELEASED
05.11.26 *[initials]*

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
2		D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50 ✓	45
2		D2252-3	FRAME	96.00 ✓	45
	2	D2252-7	FRAME	24.00 ✓	90
1		D2252-9	FRAME	10.25 ✓	90
1		D2252-11	FRAME	25.00 ✓	90
1		D2252-13	FRAME	42.00 ✓	90
1		D2252-15	FRAME	15.00 ✓	90
4		D2252-17	FRAME	19.78 ✓	53
	2	D2252-19	FRAME	95.27 ✓	45
	2	D2252-21	FRAME	30.82 ✓	90
	1	D2252-23	FRAME	30.62 ✓	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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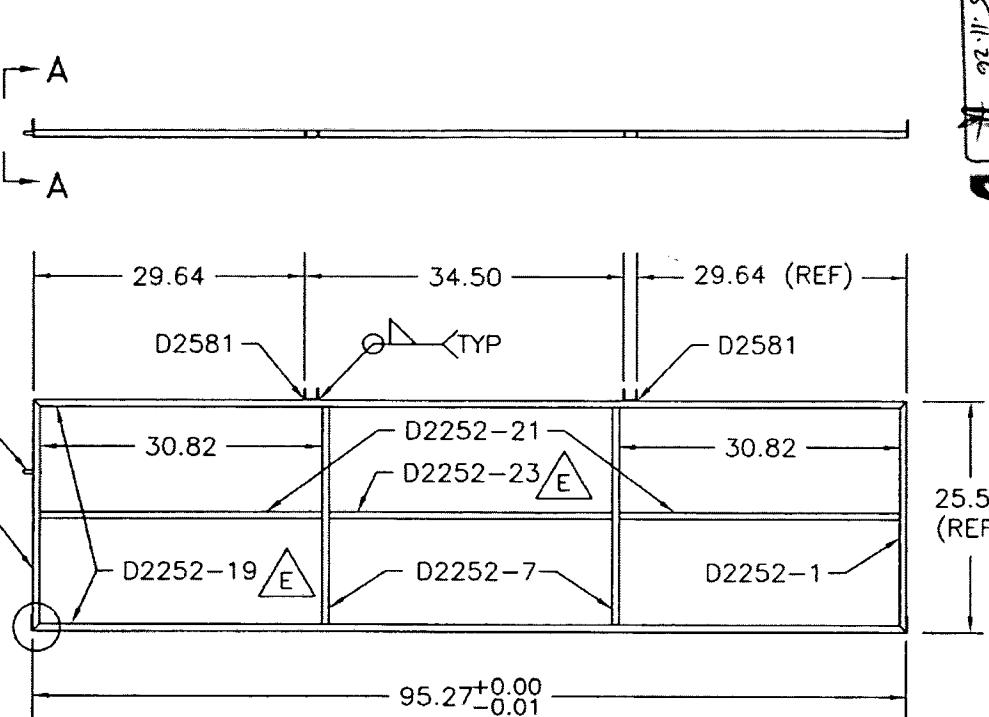
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<i>[initials]</i>	<i>[initials]</i>	D2252	SCALE
DATE	05.11.10	TITLE	NTS
		BASKET ASSEMBLY (206L)	



D2252-043 LID FRAME

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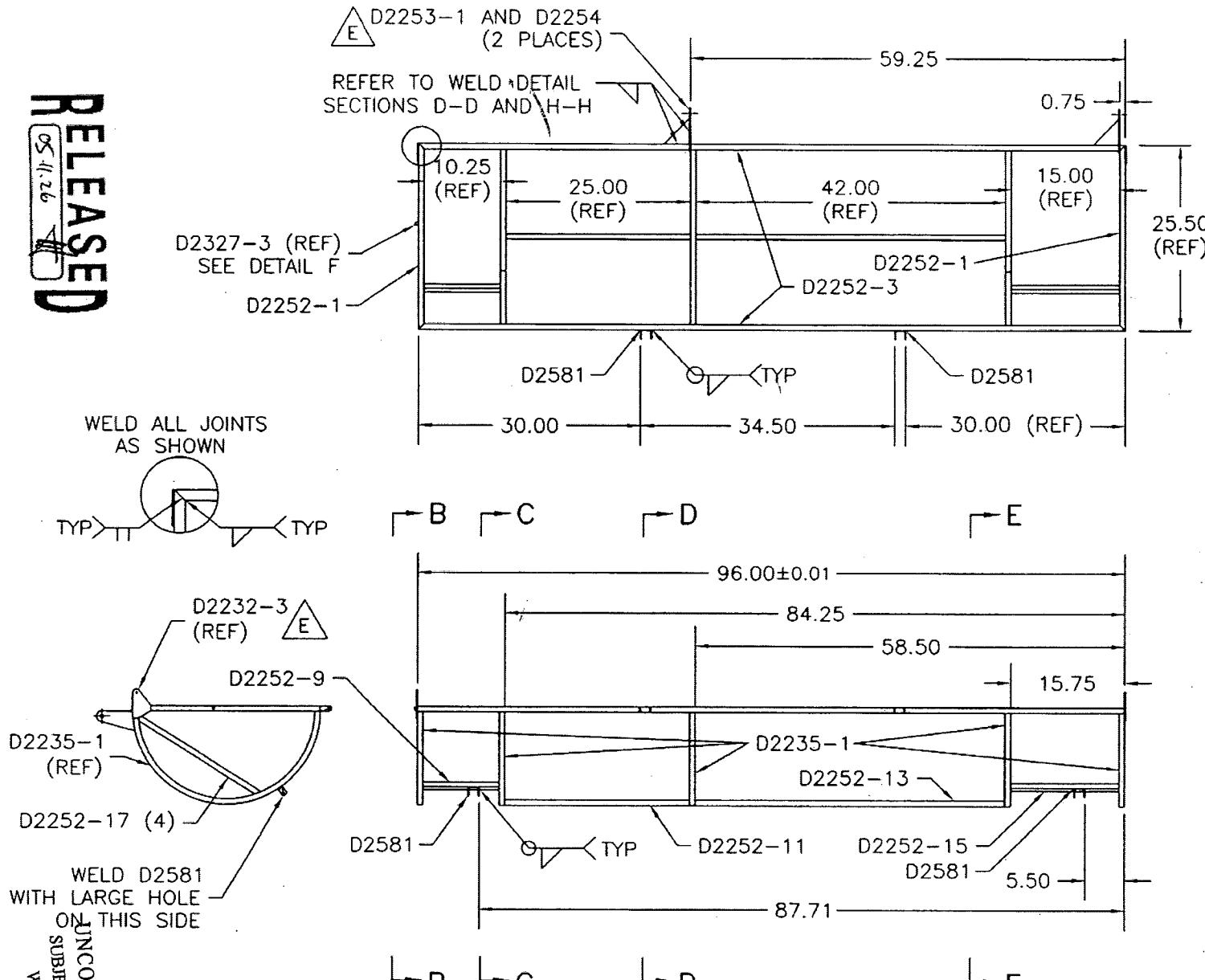
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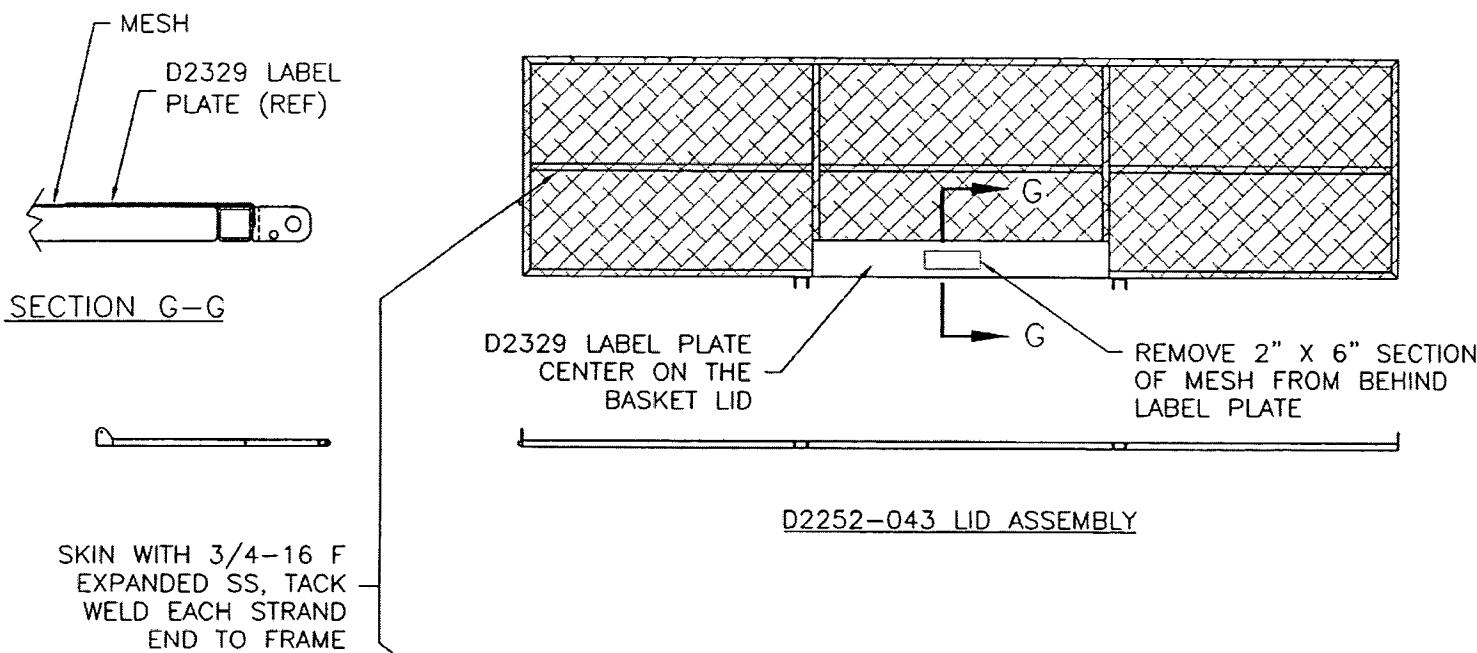
D2252-041 BASKET FRAME

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DATE 05.11.10		SHEET 4 OF 5 TITLE BASKET ASSEMBLY (206L)
		REV. E SCALE NTS



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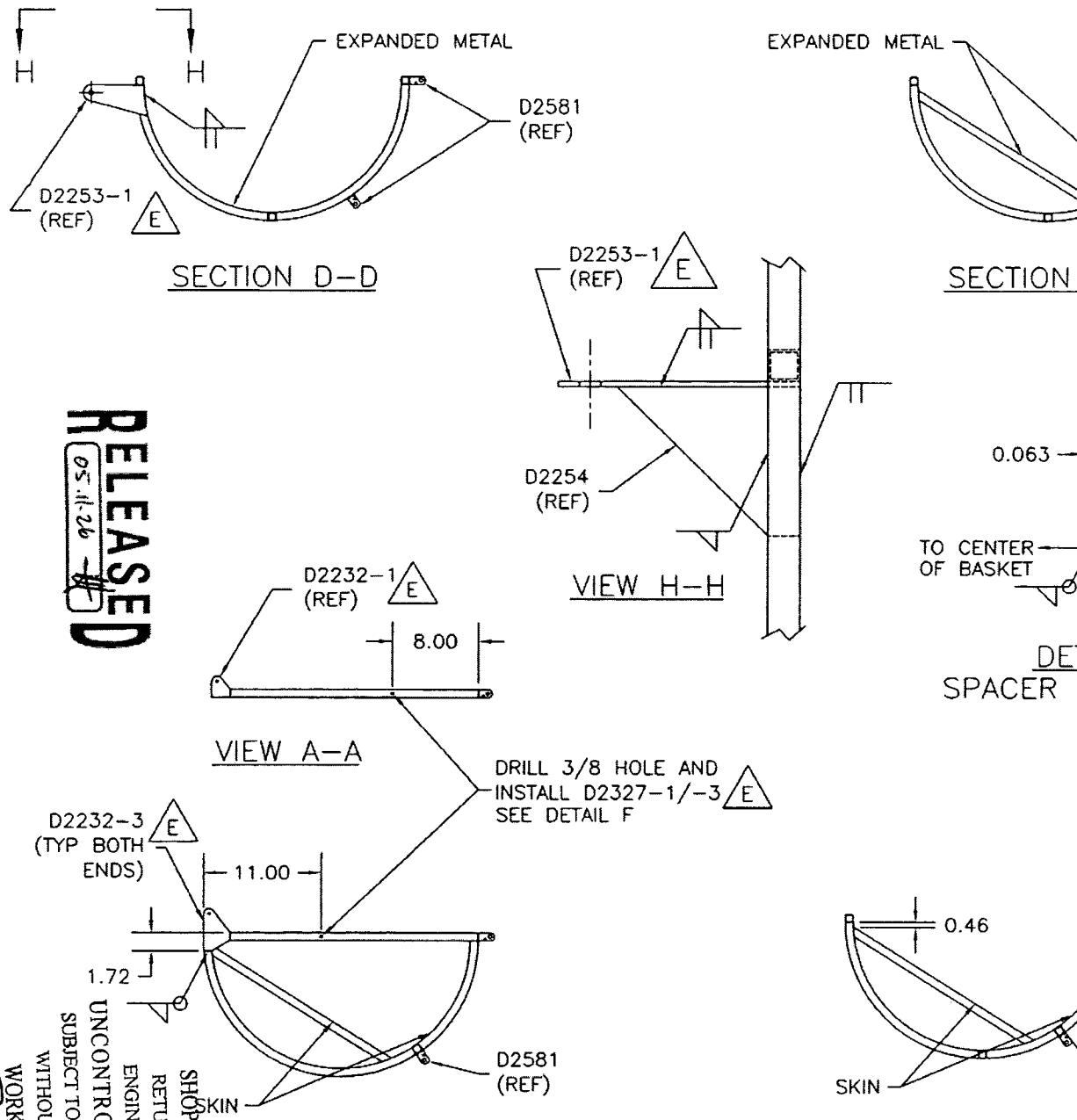
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SCALE N/A		

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